

# Work Order ID 63677

Tuesday, November 09, 2010 3:47:21 PM



Page 1

Item ID:	D3535-13	Accept		Setup	Start	
Revision ID:						
Item Name:	Wearshoe				Stop	
Start Date:	11/10/2010	Start Qty: 6.00		Cust Item ID:		
Required Date:	11/24/2010	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>10-1-9</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								

100		FLOW WATER JET	0.00						
	Waterjet								
	FLOW CNC Waterjet								
	304 . 040								
	Memo		0.00						
	1-Cut as per Dwg D3535	<input type="checkbox"/> Dwg Rev: <u>B</u>		<input type="checkbox"/> Prog Rev: <u>B</u>					
	Deburr if necessary								

110		QC2- Inspect parts off machine FAI/FAIB	0.00						
	QC								
	Quality Control								
	Memo		0.00						

120		QC8- Inspect parts - second check	0.00						
	QC								
	Quality Control								
	Memo		0.00						

B10-1-2

(B)

B10-1-12

10/16/12

(43)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63677**

Tuesday, November 09, 2010 3:47:21 PM

Page 2

Item ID: D3535-13

Accept

Revision ID:

Item Name: Wearshoe




Start Date: 11/10/2010 Start Qty: 6.00

Required Date: 11/24/2010 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00				(13)			
Brake NC	Memo 1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 joggle as per Dwg D3535 using Jig DT8158 Identify as D3535-13	0.00							
140  QC	QC5- Inspect part completeness to step on W/O	0.00				13			
Quality Control	Memo	0.00							10/11/15
150  Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				13			10-11-17
Powder Coating	Memo START TIME: 2:25 FINISH TIME: 2:55	0.00							

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Page 3

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Revision ID:

Item Name: Wearshoe

Start Date: 11/10/2010 Start Qty: 6.00

Required Date: 11/24/2010 Req'd Qty: 6.00




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	=) <i>HL</i>	<i>10/11/18</i>		<i>13</i>	<i>0</i>		
170  Packaging Packaging	Identify as per dwg & Stock Location: <i>FR-18</i>  Memo	0.00 0.00				<i>13</i>	<i>BL</i>	<i>10-11-18.</i>	
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							<i>10/11/18</i> <i>[Signature]</i>  <i>MF</i> <i>10-11-18</i>

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# Picklist Print

Tuesday, November 09, 2010 3:47:21 PM

Page 1

Work Order ID: 63677



Parent Item: D3535-13



Parent Item Name: Wearshoe


Start Date: 11/10/2010

Required Date: 11/24/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	165.0000	0.8505	5.371579	11.1	11-10-12	

Location

Loc Qty

Loc Code

MAT

161

115762

10.2

115953

150.8

MAT20

4

113062

1.398

115440

2.602

115953

13

**Dart Aerospace Ltd**

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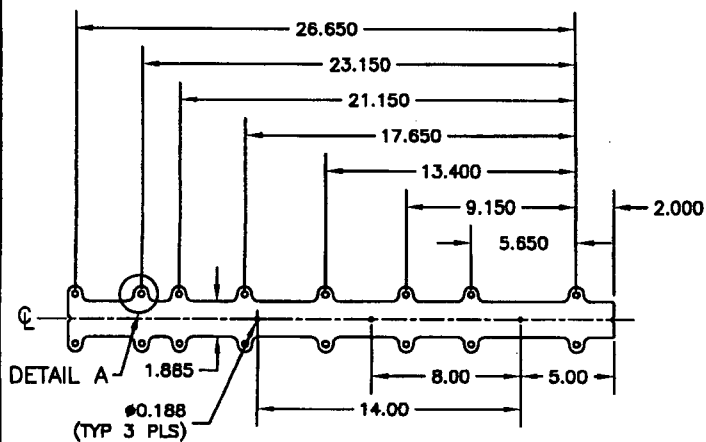
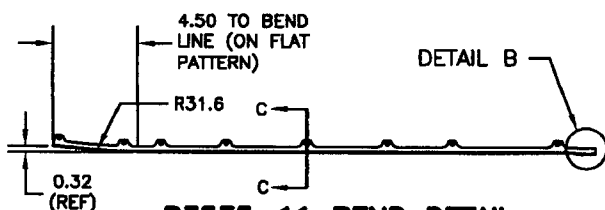
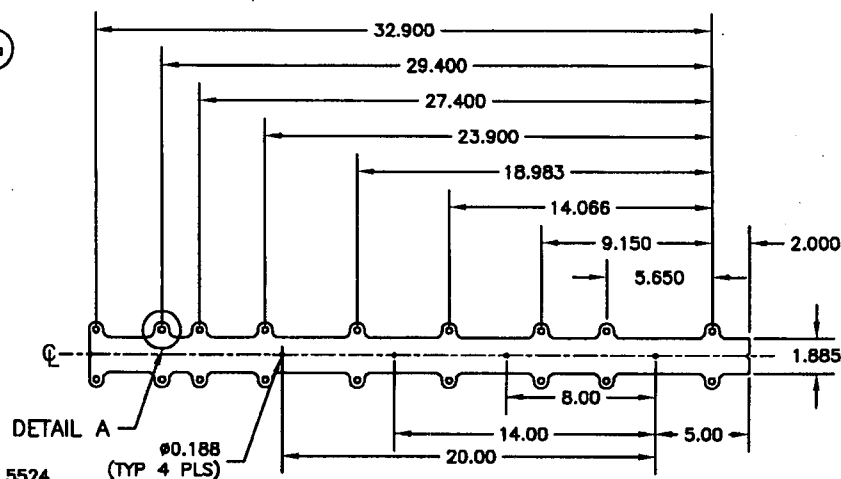
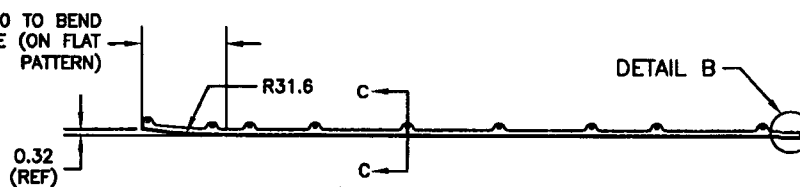


**DART**

RELEASED

07.04.24

#63677

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
#	#	D3535
DATE	TITLE	SCALE
07.04.17	WEARSHOE	1:10
REV.	DATE	DESCRIPTION
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

**Dart Aerospace Ltd**

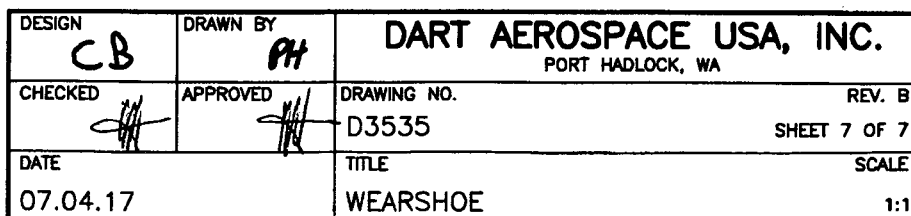
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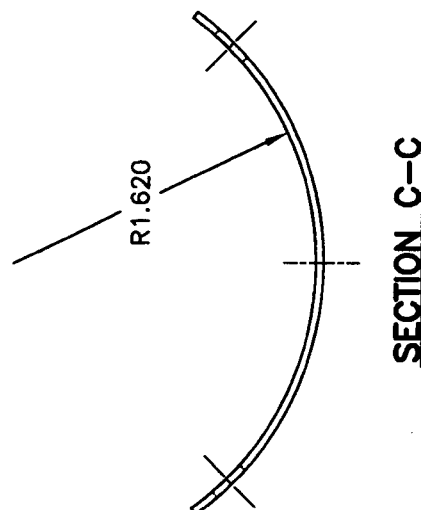
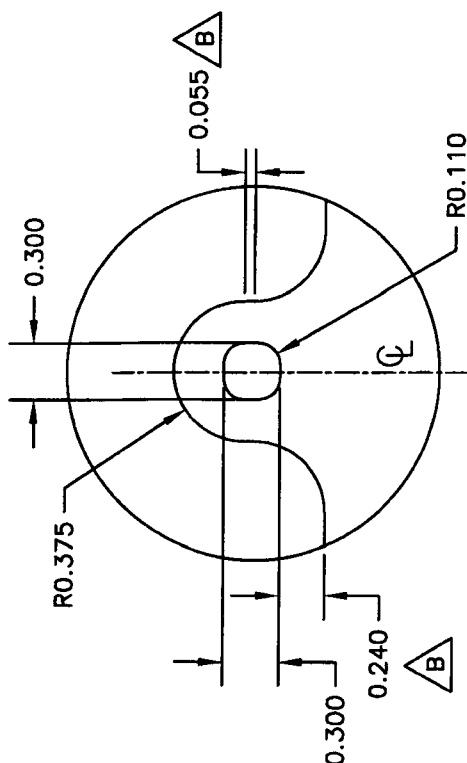
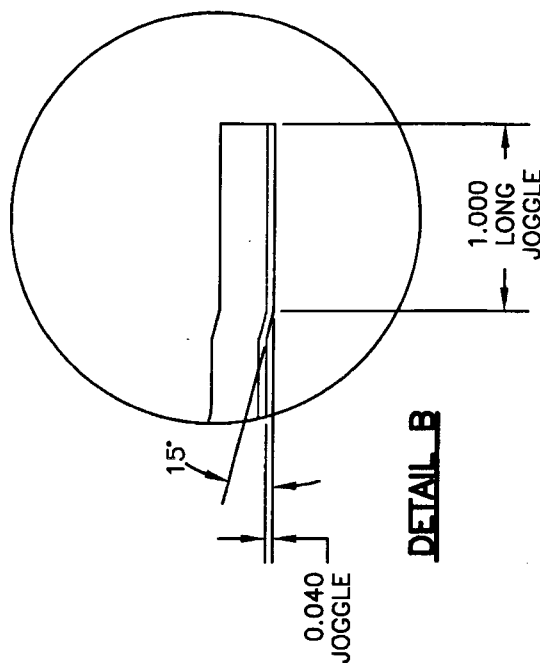
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07.04.24

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 63677
<b>Description:</b> Wearshoe		<b>Part Number:</b> D3535-13
<b>Inspection Dwg:</b> D3535	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.889	*		V 4302	
2.000	+/-0.010	2.000	*		V	
5.650	+/-0.010	5.650	*		T 1301	
9.150	+/-0.010	9.150	*		T	
14.066	+/-0.010	14.066	*		T	
18.983	+/-0.010	18.983	*		T	
23.900	+/-0.010	23.900	*		T	
27.400	+/-0.010	27.400	*		T	
29.400	+/-0.010	29.400	*		T	
32.900	+/-0.010	32.900	*		T	
Ø0.188	+0.005/-0.001	.183	*		V	
20.00	+/-0.030	20.00	*		T	
14.00	+/-0.030	14.00	*		T	
8.00	+/-0.030	8.00	*		T	
5.00	+/-0.030	5.00	*		T	
0.300	+/-0.010	.304	*		V	
0.300	+/-0.010	.304	*		V	
0.038	+/-0.010	.036	*		V	

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-11-12	<b>Date:</b> 10/11/12	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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